•			Dari Aerospaci	e Llu.
Date: Thu	rsday, 11/29/2007 11:10:38 AM			-C7
User: Kim	Johnston Proc	cess Sheet		
Customer Job Number Estimate Number	: CU-DAR001 Dart Helicopters Services : 36060	Drawing Name	: HIGH AFT X-TUBE 412	y .*
P.O. Number This Issue Prsht Rev. First Issue	: 11/29/2007 S.O. No. : : NC : // Type : LANDING GEAR : 35106	Part Number Drawing Number Project Number Drawing Revision	: D412664203 : D412-664-243 REV D : N/A : D	
Previous Run Written By	: 35106	Material Due Date	: 12/24/2007	1 Um: Each
Checked & Appro	ved By : 07/1/29	-		,
Comment	: Est Rev: 04.02.16 Reformat; Added D318			·
	Est Rev:F 06-03-29 Remove Coments on Est Rev:G 06.12.08 per ECN 886	Pick List JLM EC		
	Est Rev:H 07-04-30 As per Rev D	JLM		
Additional Produc				
Job Number:				
Seq. #:	Machine Or Operation:	Description :		
1.0	DC DOCUM	MENT CONTROL	F 1881 (8 1818) (8 18 18 18 18 18 18 18 18 18 18 18 18 18	
Comm	nent: DOCUMENT CONTROL	440,004,000,0110,000	ے جدا	P.G.11. F.
0.0	Photocopy bluefile and create labels as per PPP D	412-664-203 CHG 006 be Material	400	74,11,001
2.0	D6009129 Crosstu	pe waterial		
Comm	nent: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 E Pick:	Each(s)		
	Qty Part number Description Batch 1 D6009-129 Crosstube 13336			, ,
	Check OD = 3.500"; ID = 2.250"		J.F.	07/12/12
3.0	MORI SEIKI MORI S	EIKI CNC LATHE LARGE	: 100100 1001 1001 1001	
Comm	ent: MORI SEIKI CNC LATHE LARGE			
•	1-Fill tube with sand & install plugs DT8534 on both	n ends as per Folio FA1	66	,
	2-Turn first side as per Folio FA166		JF ON	2/16(1)
	3-Deburr & Inspect for surface damage. Repair da		er Dwg D412-664-243.	_
4.0	QC1 .INSPEC	T ALL DIM TO DIM SHEET		
Commo	ent: INSPECT ALL DIM TO DIM SHEET		T.F. 07/	12/16(1)

Dart	Apr	nena	22	l td
Dail	Aer	usua	CE	Llu

			WORK ORDER CHANGES						
TEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod-Mgr	Approval QC Inspector			
	•								
	r								
						Prod-Mgr			

Part No:	*	PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
				QA: N/C Closed:	Date:

		NCR: WORK ORDER NON-CONFORMANCE (NCR)					
	Description of NC		Corrective Action Section B		Verification	Ammental	Ammerical
STEP Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	Approval QC Inspector	
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		¥.					
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							e ,
	EP		Section A Initial	Section A Initial Action Description	Section A Initial Action Description Sign &	Section A Initial Action Description Chief Eng	Section A Initial Action Description Chief Eng

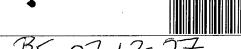
Date: Thursday, 11/29/2007 11:10:38 AM Kim Johnston . User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 36060 Job Number: Description: Seq. #: Machine Or Operation: MORI SEIKI CNC LATHE LARGE MORI SEIKI Comment: MORI SEIKI CNC LATHE LARGE 1-Turn second side as per Folio FA166 2-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243. J.F. 07/12/16 (1) 3- Remove sand and plugs 4-Scribe part # and batch # using vibrating stylus as per Dwg D412-664-243 Inside of Cuff(Donot engrave on outside of tube) 'INSPECT ALL DIM TO DIM SHEET QC1 6.0 Comment: INSPEC ALL DIM TO DIM SHEET SECOND CHECK 7.0 Comment: SECOND CHECK LANDING GEAR RESOURCE 1 8.0 LANDING GEAR 1 Comment: LANDING GEAR RESOURCE 1 1-Polish entire outside surface of crosstube INSPECT WORK TO CURRENT STEP 9.0 QC5 Comment: INSPECT WORK TO CURRENT STEP HAND FINISHING RESOURCE #1 10.0

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

INSPECT POWDER COAT/CHEMICAL CONVERSION

QC3



Comment: Inspect work & Chemical conversion Coat

11.0

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector				
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	and the second						·				

Part No:	_ PAR #:	•.	Fault Category:	-	NCR: Yes No DQA:	Date:
	•					•
					QA: N/C Closed:	Date:

NCR:	*	W	ORK ORDE	R NON-CONFORMANC	E (NCR)			
		Description of NC	1	Corrective Action Section B	Verification	A		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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Thursday, 11/29/2007 11:10:38 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Job Number: 36060 Part Number: D412664203 Job Number: Description: Machine Or Operation: BENDING MACHINE BENDING Comment: BENDING MACHINE Bend tube as per Dwg D412-664-243 using CNC bender program 412-af and Folio FT010 QC15 13.0 **CHECK OF X-TUBES** LANDING GEAR RESOURCE 1 14.0 Comment: LANDING GEAR RESOURCE 1 517 1-Drill pilot holes in tube as per Dwg D412-664-243 using drill Jig DT8550 & DT8551 2-Ream hole to finish size in tube as per Dwg D412-664-243using drill Jig DT8550 & DT8551.Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes. 3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D412-664-243 HAND FINISHING1 ANM8-01-03 Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 INSPECT POWDER COAT/CHEMICAL CONVERSION POWDER COAT/CHEMICAL CONVERSION Comment: INSPECT INSPECT WORK TO CURRENT STEP 17.0 Comment: INSPECT WORK TO CURRENT STEP 18.0 **OUTSIDE SERVICES -LG** Comment: Sub-Contracting OUTSIDE SERVICES Liquid Penetrant Inspection as per QSI 038Or Issue P/O: 5362 LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order

Dart Ae	rospace	e Ltd						
W/O:			WOF	RK ORDER CHANG	ES	····		
DATE	STEP	PROCEDURE CHANGE			Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
			•					
Part No		PAR #:	Fault Catego	ory:	NCR: Yes	No DQA :	Date: _	
					QA: N	C Closed:	Date: _	
NCR:		1	WORK ORDEI	R NON-CONFORMA	NCE (NCR)		
D. T.	0750	Description of NC	C	orrective Action Section		Verification	Approval	Approval
DATE	STEP Description of NC Section A		Initial Action Description Chief Eng Chief Eng		Sign & Date	Section C	Chief Eng	Approval QC Inspector

NCR:		WORK ORDER HOR-COM ORMANCE (NCK)						
		Description of NC		Corrective Action Section B	 3	Verification	Approval Chief Eng	A
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		Approval QC Inspector
						·		
								4

A James

Date: Thursday, 11/29/2007 11:10:38 AM Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 36060 Job Number: Description: Seq. #: Machine Or Operation: PACKAGING RESOURCE #1 19.0 **PACKAGING 1** Comment: PACKAGING RESOURCE #1 Inspect for transit damage Ensure copy of NDT results attached to work order. INSPECT WORK TO CURRENT-STEE 20.0 QC5 Comment: Inspect for damage & ensure results are as per Dwg D412-664-203 SPRAY PAINTING 21.0 Comment: SPRAY PAINTING 1-Prime inside and outside crosstube as per QSI 005 4.2 08-01-08 2-Paint outside crosstube with White Imron as per QSI 005 4.2 22.0 QC14 Comment: Inspect Spray Paint Wrap in plastic bag to protect from scratches 23.0 D3595 Rubber Cushion (per sq ft) Comment: Qty.: Total: $0.0492 \, sf(s)$ 0.0492 sf(s)/Unit Rubber Cushion (per sq ft) .630" x5.70" x2pcs 08-61-21 35126 Batch: 24.0 D2856600 Abrasion Strip Comment: Qty.: Total: 1.7640 f(s) 1.7640 f(s)/Unit Pick: Qty Part number Description Batch 41 10-10 2 D2856-600(Cut to 10.090") Abrasion Strip 25.0 D28961 Support Comment: Qty.; 1.0000 Each(s)/Unit Total: 1.0000 Each(s) Pick: Qty Part number **Description Batch** 08-01-24 30200 25 1 D2896-1 Support Page 4

Form: rorocess

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Dart Ae	rospace L	.td							
W/O:		•	WC	ORK ORDER CHANGES					
DATE	STEP	PR	PROCEDURE CHANGE			Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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		,)							
Part No		PAR #:	Fault Cate	gory: N	CR: Yes	No DQ	A:	_ Date: _	
					QA: N	N∕C Close	d:	_ Date: _	
NCR:		1	WORK ORDI	R NON-CONFORMANC	CE (NCF	R)	,		
		Description of NC		Corrective Action Section B		Verific	erification	Approval	Annroyal
DATE	SIEP	STEP Section A Initial Chief Er		Action Description Chief Eng		Secti		Chief Eng	Approval QC Inspector
									·
							_		

Thursday, 11/29/2007 11:10:38 AM Date: Kim Johnston User: **Process Sheet** Drawing Name: HIGH AFT X-TUBE 412 Customer: CU-DAR001 Dart Helicopters Services Part Number: D412664203 Job Number: 36060 Job Number: Description: Seq. #: Machine Or Operation: Chafing Shield D31891 26.0 Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s) Pick: Description Batch Qty Part number 35903 08-01-08 Chafing Sheild 2 D3189-1 MS2192028 Clamp(per MIL-DTL-8783C) 27.0 Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s) Pick: **Description Batch** Qty Part number Clamp 104413 4 MS21920-28 **2**7 80-10-80 MS2192030 clamp(per MIL-DTL-8783C) 28.0 Comment: Qty.: 2.0000 Each(s) 2.0000 Each(s)/Unit Total: clamp(per MIL-DTL-8783C) 08.01-24 batch: 106 810 LANDING GEAR RESOURCE 1 29.0 LANDING GEAR 1 Comment: LANDING GEAR RESOURCE 1 Assemble as per Dwg D412-664-203 1-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs Batch: 106 695 RT 08.01-24 6398 Magnobond Expiry Date: 08-01-24 2-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb. INSPECT WORK TO CURRENT STEP QC5 30.0 08/6 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 31.0 Comment: PACKAGING RESOURCE #1 Pick Packing Kit

N/O:			W	ORK ORDER CHAI	NGES					
DATE	STEP	PR	OCEDURE CH			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspector
				1						
										-
Part No	:	PAR #:	Fault Cat	egory:	NC	l R: Yes	No DQ	Δ.	Date:	
NCR:				DER NON-CONFOR		QA: N	I/C Close		_ Date: _	
				DER NON-CONFOR		QA: N	I/C Close	d:	_ Date: _	
NCR:	STEP			DER NON-CONFOR	MANCE	QA: N	(X)	d:		
	STEP	Description of NC	WORK ORE	DER NON-CONFORD Corrective Action S Action Descriptio	MANCE	QA: NE (NCF	(X)	d:	Date:	Approval
	STEP	Description of NC	WORK ORE	DER NON-CONFORD Corrective Action S Action Descriptio	MANCE	QA: NE (NCF	(X)	d:	Date:	Approval
	STEP	Description of NC	WORK ORE	DER NON-CONFORD Corrective Action S Action Descriptio	MANCE	QA: NE (NCF	(X)	cation on C	Date:	Approval
	STEP	Description of NC	WORK ORE	DER NON-CONFORD Corrective Action S Action Descriptio	MANCE	QA: NE (NCF	(X)	cation on C	Date:	Approval

	Johnston	Process Sheet	•
. Customer:	CU-DAR001 Dart Helicopters Services	Drawing Name: HIGH	AFT X-TUBE 412
Job Number:	36060	Part Number: D412	· 664203
Job Number:			
Seq. #:	Machine Or Operation:	Descripti	on :
32.0	AN640A 	Bolt .	
		10000 5 1/1	
Comme	Bolt	otal: 4.0000 Each(s)	
	Batch: <u>Mloy5</u>]	0	
33.0	AN641A	Bolt	
Commo	int: Other 2 0000 Fack(a)// Init - T	Tatal . 2 0000 Epob(a)	
Comme	ent: Qty.: 2.0000 Each(s)/Unit T Bolt	otal : 2.0000 Each(s)	
34.0	Batch: <u>Me 4427</u> AN960JD616	Washer	<u> </u>
S 34.0	ANSCOSO	wasiici	
Comme	, , , , , , , , , , , , , , , , , , , ,	Total: 18.0000 Each(s)	
(-18)	Washer Batch: MIS 5906	//	
35.0	MS21042L6	Nut	
4		•	
Comme	nt: Qty.: 6.0000 Each(s)/Unit T Nut	otal: 6.0000 Each(s)	
	Batch: <u>M/oy3 7</u> 9	fe	8/02/01
36.0		INSPECT 100% KITS FOR COMPLET	EMESS /
37.0	nt: INSPECT 100% KITS FOR COM PACKAGING 1	PLETENESS PACKAGING RESOURCE #1	10/60/80(2)
37.0		- An 1	
Comme	nt: PACKAGING RESOURCE #1		
	Identify and pack for shipping as	per PPP D412-664-203	·
	· · · · · · · · · · · · · · · · · · ·	l if curing time is less than 12 hrs, see step	
	Time & date of packaging:	120 8/2/18	500
:	Location:	ì	
	111 100.		

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W/O:			WORK ORDER C	HANGES				· · · · · · · · · · · · · · · · · · ·
DATE	STEP	PRO	OCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No		PAR #:	Fault Category:	NCR: Yes				rellaak

QA: N/C Closed: ____

Date: _

CR:		WORK ORDER NON-CONFORMANCE (NCR)						
		Description of NC		Corrective Action Section 8	3	Verification		
DATE	STEP	Section A	InitialAction DescriptionSign &Chief EngChief EngDate		Section C	Approval Chief Eng	Approval QC Inspecto	
						:		

Date:

Thursday, 11/29/2007 11:10:38 AM

User:

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HIGH AFT X-TUBE 412

Job Number: 36060

Part Number: D412664203

Job Number:



Seq. #:

Machine Or Operation:

Description:

38.0

QC21



FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion





Dart Ae	rospace L	.td							
W/O:			W	ORK ORDER CHANG	ES			···	
DATE	STEP	PRO	OCEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
·									
Part No	·	PAR #:	Fault Cate	egory:	_ NCR: Yes	No DQ	A:	Date:	
					QA:	N/C Close	d:	_ Date: _	
NCR:			WORK ORE	ER NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC Section A	Initial	Corrective Action Section Action Description	on B		cation	Approval Chief Eng	Approval QC Inspector
		Occion	Chief Eng	Chief Eng	Dat			Office Eng	QC IIIspecioi

DART AEROSPACE LTD	Work Order:	36060
Description: Crosstube Assembly (412 High Aft)	Part Number:	D412-664-243
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

	Х	First Article	Prototype
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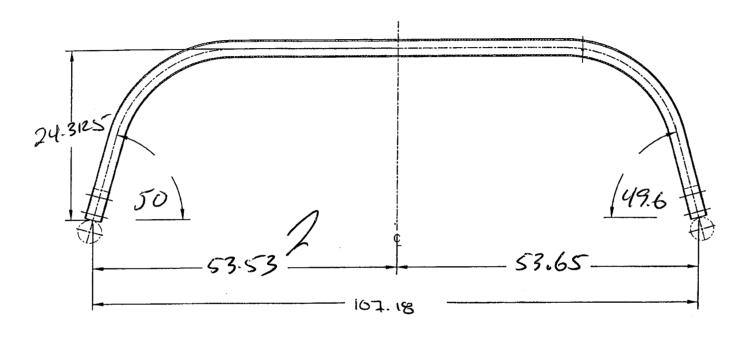
In	spection Sheet		Actual		D :	Method of	C
Dra	awing Dimension	Tolerance	Dimension	Accept	Reject	Inspection	Comments
	2.684	+0.005/-0.000	2.688'		/		
	2.748	+0.005/-0.000	2. 753'		<u> </u>	:	
	2.884	+0.005/-0.000	2.889"		<u> </u>		
	3.019	+0.005/-0.000	3.023"				
	3.163	+0.005/-0.000	3.165"				
	3.308	+0.005/-0.000	3,3/0"				
<	3.429	+0.005/-0.000	3,430				
SIDE	2.990	+0.005/-0.000	2,993				
ြွ	2.618	+0.005/-0.000	2.621"				
	0.200	+/-0.010	,200'				
	R0.063	+/-0.010	B0,063'				
	R0.500	+/-0.010	BO 500				
	4.971	+/-0.030	4.955				
					/		
	2.684	+0.005/-0.000	2.689"				
	2.748	+0.005/-0.000	2, 753				
	2.884	+0.005/-0.000	2,889"				
	3.019	+0.005/-0.000	3,024"				
	3.163	+0.005/-0.000	3.165"		-		
	3.308	+0.005/-0.000	3,310°		-		
В	3.429	+0.005/-0.000	3, 430''		/		
SIDE	2.990	+0.005/-0.000	2,993"		·/		
S	2.618	+0.005/-0.000	2.621"		,		
ļ	0.200	+/-0.010	200"	سسا			
	R0.063	+/-0.010	RO,063	سس			
	R0.500	+/-0.010	B0.500	ر			
	4.971	+/-0.030	4.968"				
	124.09	+/-0.020	124,080"				

Measured by: J. F.	Audited by:	Prototype Approval:	N/A
Date: 07/12/16	Date: 07/12/17	Date:	N/A

Rev	Date	Change	Revised by	Approved
Α	04.06.16	New Issue (P/O D412-664-203)	KJ/JLM	
В	06.03.09	Dwg Rev updated	KJ/JLM	
С	07.05.08	Tolerance updated for dimension 4.971	KJ/JLM 🚓	<i>M</i>

DART AEROSPACE LTD	Work Order:	36060
Description: Crosstube High Aft (412)	Part Number:	D412-664-203
Inspection Dwg: D412-664-243 Rev: D		Page 1 of 1

Required Dimension	Min	Max
Height	24.24	24.50
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.70



	comments	
QC15 Inspection		

Rev	Date	Change	Revised by	Approved
Α	07.02.06	New Issue	KJ/JM	
В	07.05.08	Dimensions updated per Dwg rev. D	KJ/JLM 🚓	fr

Date



	DESIGN DRAWN BY H			DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
	CHECK	P	APPROVED	DRAWING NO. REV. I D412-664-243 SHEET 1 OF 3				
ħ	DATE		1	TITLE SCALE				
١	07.0	3.09		CROSSTUBE ASSEMBLY (412 HI AFT) NTS				
	Α		01.10.17	NEW ISSUE				
	В		05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES				

		С	06.10.27	REMOVE D2856-600-1087, ADD D2732-058 & MAGNOBOND 6398 MS21920-32 WAS MS21920-30		
		D	07.03.09	REMOVE D2732-058, CHANGE TO D3595-063-570		
	Part Number	er	Description			
	D412-664-243	3	CROSSTUBE ASSEMBLY	(412 HIGH AFT)		
	D6009-129		CROSSTUBE			
D3595-063-570		0	RUBBER CUSHION			
	D2896-1		SUPPORT			

GENERAL NOTES:

Qty X

2

4

2 A/R

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

MATERIAL: MANUFACTURED FROM D6009-129 FINISHED LENGTH = 124.09±0.020

MS21920-28

MS21920-30 D3189-1

D2856-600-1009

MAGNOBOND 6398

3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2 PAINT OUTSIDE PER DART 005 4.2

PART IS SYMMETRIC ABOUT CENTERLINE.

RUN-OFF PART, BLEND OUT EDGE LONGITUDINALY, TRANSITION SHOULD BE SMOOTH

ABRASION STRIP

CHAFING SHIELD

CLAMP (OR MS21920-32)

TYPE II, CLASS 2 ADHESIVE)

ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100.

CLAMP

BEND PROGRESSIVELY WITH A MINIMUM OF 8 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.

LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.

SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.

INSTALL D2856-600-1009 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE PER QSI 035.

ENGINEERING UNCONTROLLED COPY 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE_{SUBJECT} TO AMENDMENT BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE WITHOUT NOTICE WORK ORDER NO. 36060 UNACCEPTABLE

SHOP COPY

RETURN TO

11) APPLY A 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 TO THE SURFACE OF D2896-1 THAT WILL BE IN CONTACT WITH THE CROSSTUBE PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.

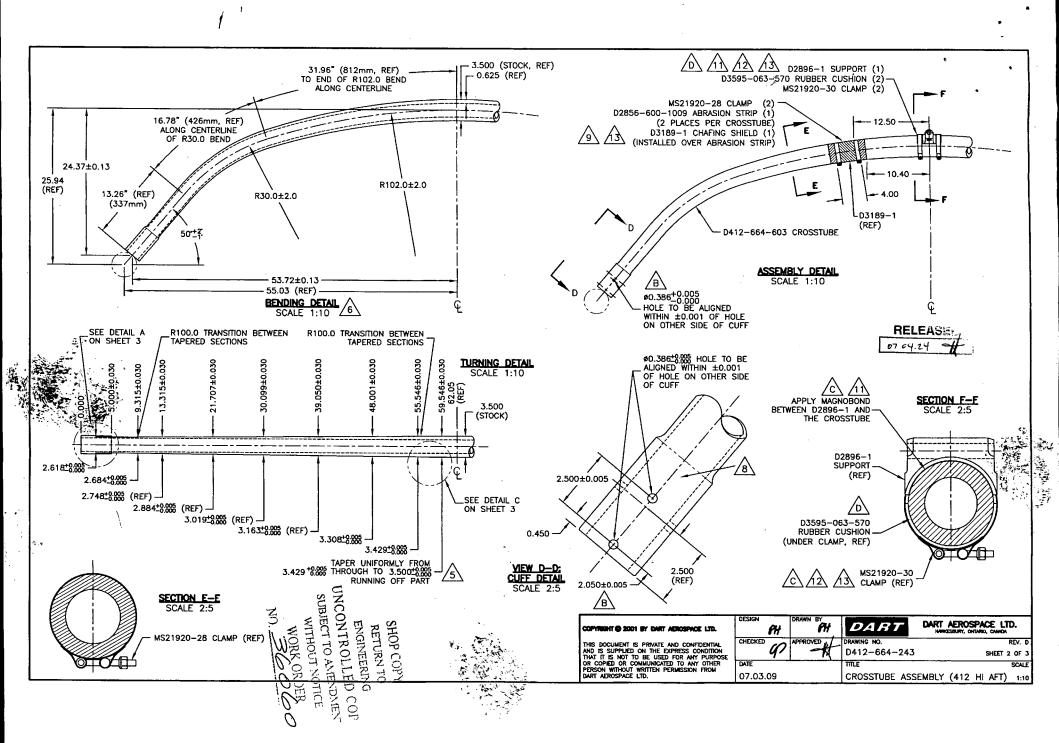
12) INSTALL MS21920-30 CLAMPS (OR -32) WITH D3595-063-570 RUBBER CUSHIONS TO SECURE D2896-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE CROSSTUBE SUPPORT.

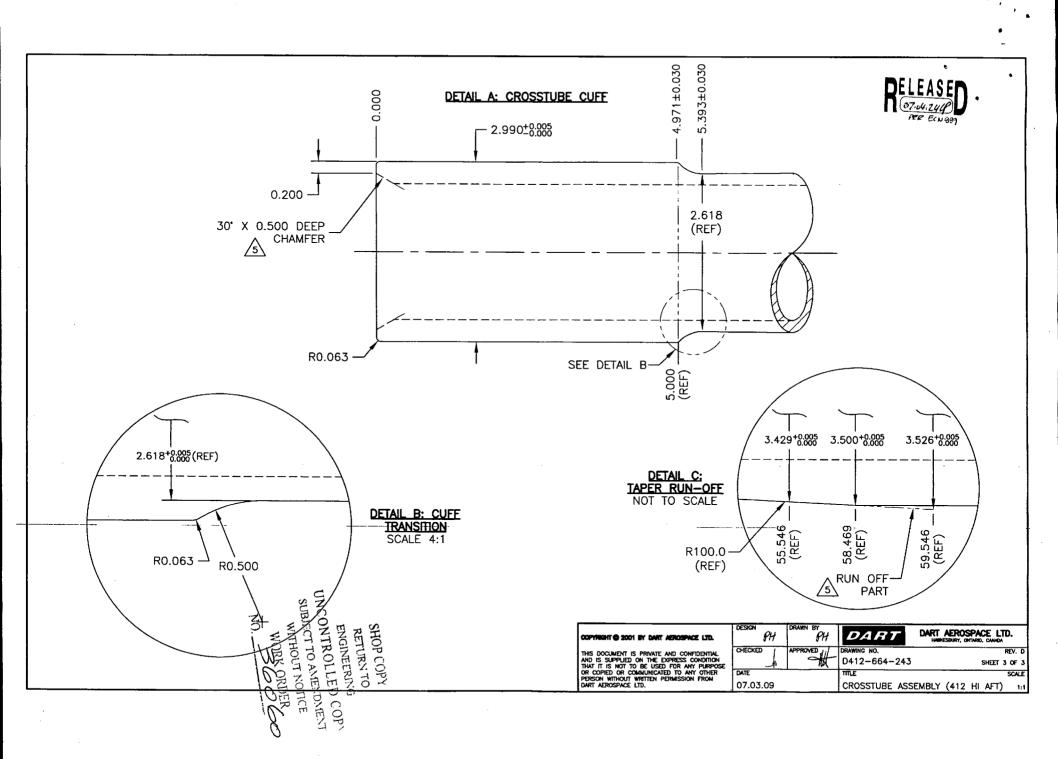
13) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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	•
ACUREN	

LIQUID PENETRANT TEST REPORT

P - 8-1202

ACUREN	•		2010 1 2			· · · · · ·		-		· · · ,
. •								PAGE	1	OF <u>1</u>
CLIENT	DART AREOSPA	ACE			DATE	JAN. 4, 2	800	TIME	AM □	PM 🗆
ATTENTION	LINDA LACELLE	Ē			ACUREN JOB NO.	188-8-01	202			
Address	1270 ABERDEE	N ST. HAWKESBUF	RY ONT.		PO/WO No.					
,					Work Location	HAWKES	BURY			
					- ACCEPTANCE ST	D. ASTM 14	17/QSI-038	REV./D/	TE 2005	
PROJECT	206B AFT X-TUI	BE, 206L FWD X-TU	BE. HIGH AF	r X-TUB	- E 412					
ITEM(S) EXAMINED		36052, 36054, 36060				·				·
HEM(S) EXAMINED	JOB# 3 30031, 3	30032, 30034, 30000	, 50003							
JOB DESCRIPTION	N	PROCEDURE No.	LT-0002 RE\	/./DATE		TECHNIQUE I	No. LT-0002-0	2 REV./D/	ATE.	
	67201, D20666710		·			DYNED ALU		hickness		
Scope WET F	LOURESCENT	LIQUID PENETR	ANT INSPEC	CTION	CARRIED OUT	ON 100% C	OF EXTERNAL	SURFAC	E	
		-								
TEST DETAILS					· · · · · · · · · · · · · · · · · · ·					
Method	☑ Fluo	rescent	☐ Visible		⊠Water Wash		☐ Solvent Rem	novable	☐ Post E	mulsified
	MAGNAFLUX		- 101010		Black Light S/N	8178	☑Output > 100	0 μ W/cm²	⊠Ambi	ent < 2 fc
Penetrant	ZL67	Minimum Dwell ti	me 45	Min.	Lighting Equip.	☑Flashlight	□ Troublelight		ut>100 fc @	surface
Penetrant Rémove		Minimum Dry tim		Min.	Other			Cal Du	e Date	MAR 08
· · · · · · · · · · · · · · · · · · ·	SKDS2	Minimum Dwell ti		Min.	Light Meter S/N			Cai Du	e Date	VIAIN OO
Developer Type TEST SURFACE	<u> </u>	redus a Aqueous	, <u>a</u> D	у	<u> </u>					
Surface Condition	☑ As Grou	nd 🗆 A	s Welded		☑Machined	☐ Shot E	Blasted		Clean Bare	e Metal
Surface Temperatu			°C/ 20°F to 10	°C/50°F			0°F to 52°C/125°	F D	> 52°C/12	5°F
RESULTS-	(METRIC	☐ IMPERIAL)								
item	Com	ments	Accept	Reject						
Job # 36051	: ACCEPTABLE									
36052	: ACCEPTABLE		1							
36054	: ACCEPTABLE									
36060	: ACCEPTABLE	7			 					
	: ACCEPTABLE) 						
30003	. MOOLI INDEL	a mile mer Aramat, har der ver ver ha ha till e delege meg de gelegel i men som								
						 				
	grama na modulos, se e se é e los culturas habitos despiés de	and the state of t								
	ar p. n.			·· ·· · · · · · · · · · · · · · · · ·						
			And the second of the second o							
It is expressly understood and are not intended nor for the engineering, manu- nerein exceed the amoun Standard of Care	I that all descriptions, co can they be construed a facture, repair and use of t paid for such services. s provided, Acuren Grou	pervices extends only to tho imments and expressions of its representations or warrandecisions as a result of the plnc. uses the degree, can ed by Acuren Group Inc.	of opinion reflect the nties. Acuren Grou data or other inform	e opinions of the opinion of the opinions	or observations of Acure ot assuming any respons ided by Acuren Group Ir	en Group Inc. bas sibilities of the ow nc. In no event sh	ed on information and ner/operator and the o nall Acuren Group Inc.	assumptions sowner/operator is liability in res	retains comple pect of the sen	te responsibility vices referred to
SIGNATURES	The state of the s					· · · · · · · · · · · · · · · · · · ·	<u> </u>			
	otivo						DTR:	¥		
Client Represent		print		0	signature			·		
Technician (Signal	ture):		******	<i>"</i>	din	marine, say same	Report Reviewed by:			
Name (Print):	FF	REDERICK CHAG	NON		BRENDON MIR	AN		Name		initials
	CGSB Le CGSB Re	1 st technician vel <u>II</u> SNT Le ea. No 10560		CGSB Lev	2 nd technician vel <u>II</u> SNT g. No 12247	Level		٠		

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